

Work Order ID 85455

85455

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June-08-12 10:01:27 AM

Item ID: D2274

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Radius Block

Start Date: 08/06/2012 Start Qty: 200.00

200

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 200.00

200

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/08

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2274	Rev F								
100		0.00							
100	SHEAR								
Shear		0.00	PO	12/06/17		200	Ø		
Shear	Memo blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces								
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS I		0.00	PO/B.A	12/06/18		200	Ø		
HAAS CNC vertical machine #1	Memo Machine as per folio D2274								
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC		0.00	PO/B.A	12/06/18		200	Ø		
Quality Control	Memo								

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Stop *NR2*

**Insp.
Stamp**

201

202

202

Jan 17-6-19

0.00

Memo

Hand Finishing

200

7AG 12-6-25

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>001</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

9/26/20 200

200 12/06/20 JB

12/6/21

MS 12/06/20

Picklist Print

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Work Order ID: 85455

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Parent Item: D2274

D2274

Parent Item Name: Radius Block

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP H00.05.18Added inspection level 8EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	33.9030	0.0916	19.28421			

M6061T6B00750X00 125

6061-T6 Bar .750 x .125

**

70 12/06/17

Location

Loc Qty

Loc Code

MAT001

11.168

116406

2.75

117653

8.418

MAT003

22.735

120603

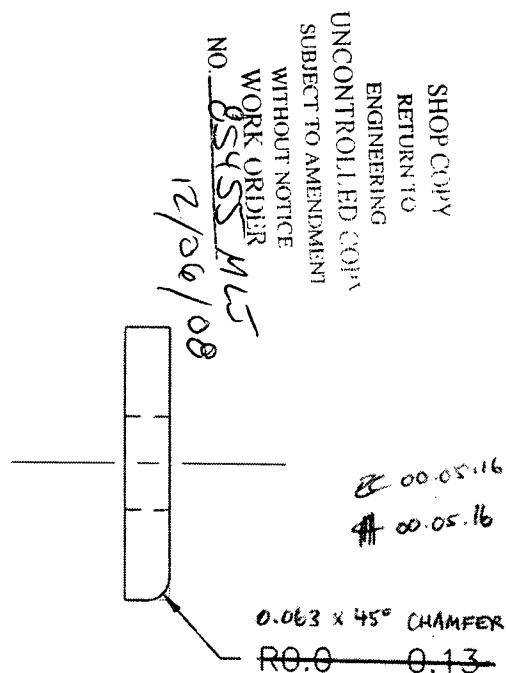
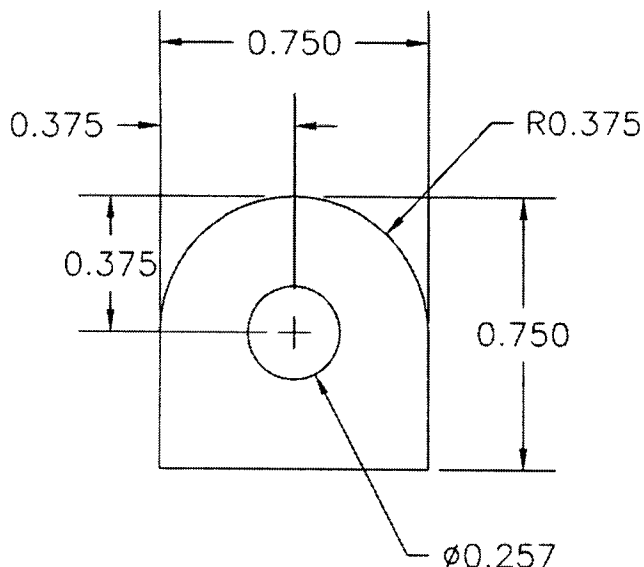
22.735

19.4



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/13 KE



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED